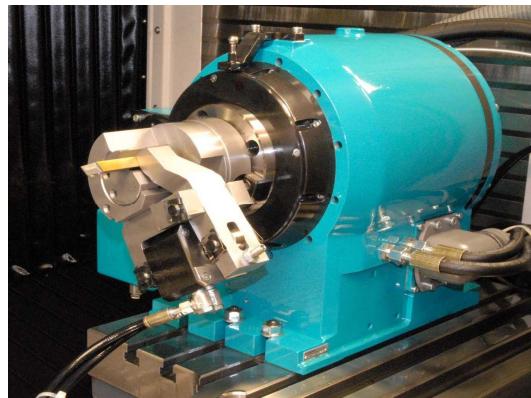


## Gear Blade Oerlikon

### A12-350

The profiled Gear Blades are ground with DXF based Profileoperation being clamped horizontally in a specially designed automatic clamping device. The 1A1-wheel is used on both sides to grind either the pressure side of the blade or the clearance side of the blade and the cutting face.



### 1. Cycletime for Resharpening

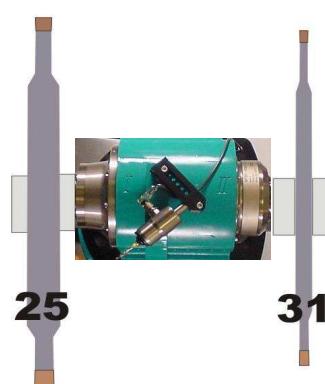
Tool specifications inner blade and outer blade 469; 14 x 17 x 115 mm Material HSS						
Operations	Probe	Prs.Side rough	Clr.Side rough	Prs.Side fin.	Clr.Side fin.	Face
Feed [mm/Min]	2000	85	85	90	90	80
Power [kW]		1.5	1.5	0.7	0.7	0.9
Cutting feed [m/s]		28	28	32	32	28
Used wheels		25	25	31	31	31
Grinding time [s]	18	36	36	28	28	32
Total cycle time	2 Min 58					



The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

25 Ø250 1A1 B181  
31 Ø250 14A1 B54



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGC  
Control: Fanuc 31i B5  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5

Responsible engineer: 31.10.2014, ADA

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